

Date: Monday, 06/04/2009 2:26:52 PM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D206-642-512
Job Number : 46941	
Estimate Number : 10804	
P.O. Number :	Part Number : REWORK10
This Issue : 06/04/2009 S.O. No. :	Drawing Number : REWORK
Prsht Rev. : NC	Project Number :
First Issue : / / Type : SKIDTUBES	Drawing Revision :
Previous Run : 46796	Material :
Written By :	Due Date : 13/04/2009 Qty: 1 Um: Each
Checked & Approved By :	
Comment :	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: PULL FROM STOCK:

D206-642-511

B34582, 42164, 42165, 43309, 44507, 44510

D206-642-512

B42164, 43311, 44511

6 = 6A1 9
3

INSPECT FOR LOOSE BOLTS, INSERTS,
 LPS LEAKAGE, AND DEFORMED GASKETS.

IF OK, THEY MAY BE REPACKAGED AND RETURNED TO STOCK

IF ANY OF THE ABOVE IS AN ISSUE, PLEASE CONTINUE TO

SEQUENCE 2

9/4/14 SP

2.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

PULL FROM STOCK:

1 X D206-642-512 B 44510 (4) (13 1344507)

REMOVE ALL WEARPLATES, GASKETS AND END CAP

DISCARD SCREWS, WASHERS AND GASKETS

(KEEP WEARPLATES TO RE-ASSEMBLE)

PRESSURE WASH INSIDE AND OUTSIDE OF
 TUBE TO REMOVE ANY LPS3

09-05-04 X2

DART

TRANSPORT CANADA APPROVAL # 09-89

TEL.: 1-613-632-3336
FAX: 1-613-632-4443

P/N	D206-642-511	CHG	CHG003
DESC.	Float Skidtube LH	STC	SH98-4
LOT	B44510	STC	SA00475SE
MODEL	206L/L1/L3/L4/407	STC	

US PATENT # 5735484
CANADA FOREIGN PATENTS PENDING

MADE IN CANADA

DART

TRANSPORT CANADA APPROVAL # 09-89

TEL.: 1-613-632-3336
FAX: 1-613-632-4443

P/N	D206-642-511	CHG	CHG003
DESC.	Float Skidtube LH	STC	SH98-4
LOT	B44507	STC	SA00475SE
MODEL	206L/L1/L3/L4/407	STC	

US PATENT # 5735484
CANADA FOREIGN PATENTS PENDING

MADE IN CANADA

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Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-642-512

Job Number: 46941

Part Number: REWORK10

Job Number:



Seq. #:

Machine Or Operation:

Description :

3.0

D206642512

Float Skidtube RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Float Skidtube RH

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

REASSEMBLE PER DRWG D3274 REV.D

NEW SCREWS, WASHERS AND GASKETS REQUIRED:

16078X AN3C4A B 111572
16078X AN960C10L B 111424
2 1X D3536-15 B 46883
2 1X D3536-23 B 44646
2 1X D3536-35 B 38905
2 1X D3536-39 B 33966

✓ USE EXISTING WEARPLATES AND CAP

— DO NOT SPRAY WITH LPS!!

M111081 exp: 10/20
* use a drop of Sikaflex in each insert!
Scrap end cap and replace it hole!
A1026461346237(X2)

91 09-05-04 - (X1)

6.0

AN3C4A

BOLT



Comment: Qty.: 80.0000 Each(s)/Unit Total : 80.0000 Each(s)
BOLT M 111572 *

7.0

AN960C10L

washer



Comment: Qty.: 80.0000 Each(s)/Unit Total : 80.0000 Each(s)
washer M 111424 *

91 09-05-04 (X1)

Date: Monday, 06/04/2009 2:26:53 PM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-642-512

Job Number: 46941

Part Number: REWORK10

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

D353615

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

B 4 6 8 8 3

X

JY

9.0

D353623

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

B 4 4 6 4 6

X

JY

10.0

D353635

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

B 3 8 9 0 5

X

JY

11.0

D353639

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

B 3 3 9 6 6

X

JY

09-05-04

X2

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/05/04

X2

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

09/05/04

RE-PACKAGE USING NEW B/N
NEW LABELS REQUIRED

ENSURE ORIGINAL KIT PACKAGED WITH SKIDTUBE

CHG003

09/05/04 (2) + 7

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/08

Job Completion



DART			
TRANSPORT CANADA APPROVAL # 09-89			
PN	D206-642-511	CHG	CHG003
DESC	Float Skidtube LH	STC	SH98-4
LOT	B42164	STC	SA00475SE
MODEL	206L/L1/L3/L4/407	STC	
US PATENT # 5735484 CANADA FOREIGN PATENTS PENDING			
MADE IN CANADA			

MF
09-05-08

Item Status

03/04/2009 7:21:20AM Page 111 of 477

		Available	On Hand	On SO	Location	Lot #	Change #	Qty				
D206-642-511	Float Skidtube LH	6	6	0	MAIN	34582	CHG003	1				
					MAIN	42164	CHG003	1				
					MAIN	42165	CHG003	1				
					MAIN	43309	CHG003	1				
					MAIN	44507	CHG003	1				
					MAIN	44510	CHG003	1				
									6			
		2	2	0	OFFS01	40236	CHG003	1				
					OFFS01	40237	CHG003	1				
												2
									8			
		D206-642-512	Float Skidtube RH	3	4	1	MAIN	42168	CHG003	1		
MAIN	43311						CHG003	1				
MAIN	44511						CHG003	1				
MAIN	46796						CHG003	1				
							4					
							4					
D206-642-513	Skidtube LH	1	1	0	MAIN	42291	CHG002	1				
												1
		1	1	0	OFFS01	42292	CHG002	1				
												1
							2					
D206-642-514	Skidtube RH	2	2	0	MAIN	42276	CHG002	1				
					MAIN	42294	CHG002	1				
												2
					1	1	0	OFFS01	42293	CHG002	1	
									1			
									3			
D206-642-541	Replacement Skidtube	1	1	0	MAIN	34772	CHG003	1				
												1

REFERENCE ONLY

gme

L Lacelle

From: Bill Beckett [bbeckett@dartaero.com]
Sent: April 6, 2009 1:23 PM
To: 'L Lacelle'
Cc: 'Mike Petsche'; 'David Shepherd'; 'Jason Murdoch'
Subject: RE: uncured sikaflex+LPS3 =

Linda,

I want all Float Skidtubes removed from stock and opened for inspection. If we see no signs of LPS leakage, then I think they are OK as is. We will decide once they are open. Otherwise, they will need to be disassembled, interiors pressure washed and re-assembled with new rubber gaskets.

Bill

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: April 6, 2009 1:08 PM
To: 'Mike Petsche'; 'David Shepherd'; 'Bill Beckett'; 'Jason Murdoch'
Subject: RE: uncured sikaflex+LPS3 =

So, are we going to rework everything in stock then?

From: Mike Petsche [mailto:mpetsche@dartaero.com]
Sent: April 6, 2009 9:11 AM
To: 'L Lacelle'; 'David Shepherd'; 'Bill Beckett'; 'Jason Murdoch'
Subject: RE: uncured sikaflex+LPS3 =

Also....LPS3 + rubber gaskets = really really weak gasket!

Left a chunk for rubber on a cup of LPS3 over the weekend. I was able to split the rubber apart by squeezing it with my finger nails. (I'm not able to do this with new rubber).....it DEFINITELY degrades the rubber

From: Mike Petsche [mailto:mpetsche@dartaero.com]
Sent: Thursday, April 02, 2009 2:46 PM
To: 'L Lacelle'; 'David Shepherd'; 'Bill Beckett'; 'Jason Murdoch'
Subject: uncured sikaflex+LPS3 =

Liquid!

The LPS3 dissolves the sikaflex rather effectively.....

FYI.....

Mike Petsche
Design Manager
DART Aerospace
phone: 613-632-5200
mobile: 514-833-1657
skype: mike.petsche

06/04/2009

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries